

Wo
Mar
Item
Revi
Item
Star
Req
Refe
App
Sequ
Wor
120
*1
QC
Quali
130
*1
Brak
Brake
140
*1
Sma
Small

Work Order ID 80658

March-06-12 2:41:43 PM

80658

Page 1

Item ID: D4434-047
Revision ID: ~~PRELIM~~
Item Name: Cover Assembly

Accept

N900040100

Setup Start *NS1*


Stop *NS2*

Start Date: 2/24/12 Start Qty: 10.00
Required Date: 3/15/12 Req'd Qty: 10.00
Reference:

10

10

Cust Item ID:
Customer:

Approvals: Process Plan:  Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr	Revision Nbr
D4434	B

100

0.00

100



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D4434-Z as per Dwg
Dwg Rev: 
Prog Rev: 

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

1B12-3-8

10

1B12-3-8

Work Order ID 80658

March-06-12 2:41:43 PM

80658

Page 3

Item ID: D4434-047
Revision ID: PRELIM
Item Name: Cover Assembly

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 2/24/12 Start Qty: 10.00 ***10***
Required Date: 3/15/12 Req'd Qty: 10.00 ***10***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

8/2/03/13

(40)

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

10Xφ M-L 12/03/13

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

10 φ M-L 12/03/13

Work Order ID 80658

80658

Page 4

March-06-12 2:41:43 PM

Item ID: D4434-047
Revision ID: PRELIM
Item Name: Cover Assembly

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 2/24/12 Start Qty: 10.00 ***10***
Required Date: 3/15/12 Req'd Qty: 10.00 ***10***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

180

Small Fab

Small Fab

Memo

Install rivet as per dwg

0.00

0.00

(10)

FF 12-03-14

185

185

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

5/26/14

(10)

186

186

Powdercoat

Powder Coating

Black Sandtex(Ref.4.3.5.7) per QSI005 4.3

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10h05
320°F
10h35

0.00

0.00

m115128

10 & (20) 12/03/16.

Work Order ID 80658***80658***

Page 5

March-06-12 2:41:43 PM

Item ID: D4434-047
Revision ID: PRELIM
Item Name: Cover Assembly

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 2/24/12 Start Qty: 10.00 ***10***
Required Date: 3/15/12 Req'd Qty: 10.00 ***10***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

187

QC3- Inspect Part Finish

0.00

187

QC

Memo

0.00

Quality Control

10X ~~QC~~ M-1 12/03/16

190

Identify as per dwg & Stock Location: _____

0.00

190

Packaging

Memo

0.00

Packaging

12/3/16 sd (10)

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/3/19 JF

12/03/14
(10)

Picklist Print

March-06-12 2:41:42 PM

Page 1

Work Order ID: 80658

Parent Item: D4434-047

Parent Item Name: Cover Assembly

Start Date: 2/24/12

Required Date: 3/15/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP RevB 11.12.22 per PA5
EC verified by:JLM IPP RevC 12.01.24 PER DWG REV.A DD VERF:EC
IPP RevD 12.03.05 per REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040
6061-T6 .040 Sheet

Purchased No

100 sf 292.3670 0.5789 6.0936842

Location

Loc Qty

Loc Code

MAT021

292.367

117653

27.91

120154

90

120218

174.457

MS20470AD4-3

Purchased

No

185 Each 5,874.0000

2 20

Rivet - Universal Head

Location

Loc Qty

Loc Code

Mezz

5874

1642

1240

2193

4634

B12-3-8

(10)

(10) FF 12-03-14

120218

20

DART AEROSPACE LTD		Work Order: 84659
Description: Bracket		Part Number: D4434-7
Inspection Dwg: D4434	Rev: AB	Page 1 of 1

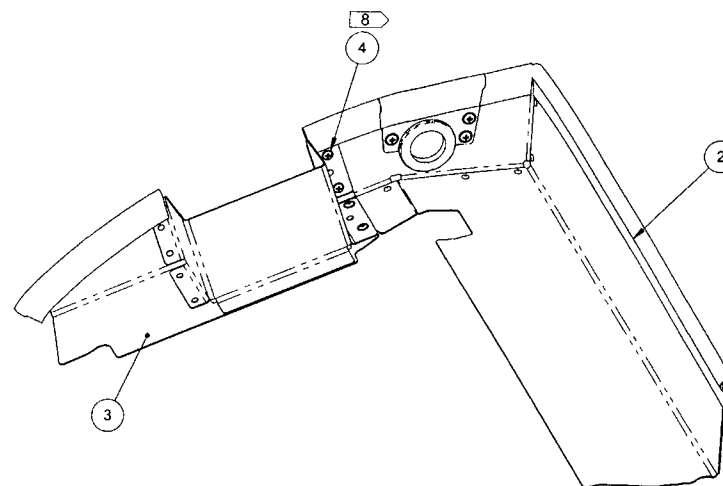
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	1.01	✓		V (B2)	
1.42	+/-0.030	1.416	✓		V	
1.70	+/-0.030	1.697	✓		V	
2.24	+/-0.030	2.237	✓		V	
3.81	+/-0.030	3.811	✓		V	
10.41	+/-0.030	10.41	✓		T (B2)	
11.98	+/-0.030	11.98	✓		T	
12.52	+/-0.030	12.52	✓		T	
12.80	+/-0.030	12.80	✓		T	
14.22	+/-0.030	14.22	✓		T	
0.35	+/-0.030	.356	✓		V	
0.85	+/-0.030	.859	✓		V	
1.75	+/-0.030	1.748	✓		V	
2.65	+/-0.030	2.666	✓		V	
2.95	+/-0.030	2.954	✓		V	
5.53	+/-0.030	5.53	✓		V	
5.82	+/-0.030	5.819	✓		V	
6.13	+/-0.030	6.13	✓		V	
5.02	+/-0.030	5.02	✓		V	
5.36	+/-0.030	5.366	✓		V	
5.64	+/-0.030	5.64	✓		V	
2.34	+/-0.030	2.340	✓		V	
2.65	+/-0.030	2.650	✓		V	
3.02	+/-0.030	3.020	✓		V	
11.24	+/-0.030	11.24	✓		T	
11.59	+/-0.030	11.59	✓		T	
11.94	+/-0.030	11.94	✓		T	
0.040	+/-0.010	.039	✓		V	

Measured by: B	Audited by: S	Preliminary Approval:
Date: 12-3-98	Date: 12/13/98	Date:

Rev	Date	Change	Revised by	Approved
A	12.02.01	New Issue	KJ	

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4434-041	FWD BRACKET ASSEMBLY
2	1	D4434-043	FWD INBOARD BRACKET ASSEMBLY
3	1	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
4	4	AN525-832R7	SCREW



D4434-041 FWD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.43 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

W/O 80658

RELEASED
2012-05-02

B	RE-DESIGN D4434-9/-9F (ZN BS-14, A5-15)	RF	12.02.22
A	NEW ISSUE	RF	12.01.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4434	SHEET 1 OF 15
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	COVER ASSEMBLY	NTS
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7

6

5

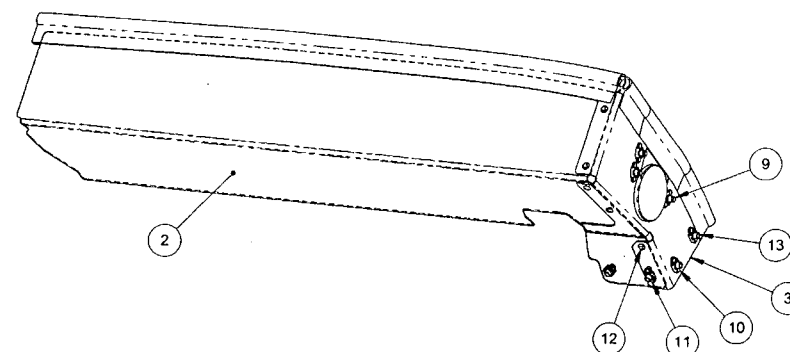
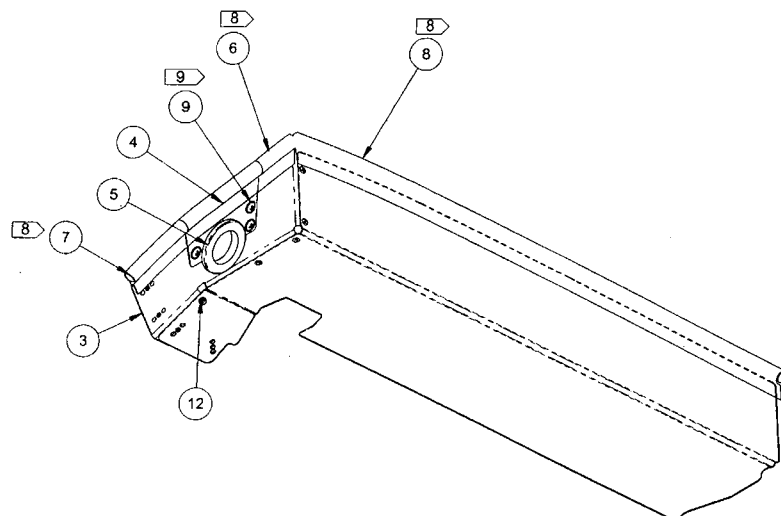
4

3

2

1

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4434-043	FWD INBOARD BRACKET ASSEMBLY
2	1	D4434-1	BRACKET
3	1	D4434-9	BRACKET
4	1	D4435-041	BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	1	D4441-1-017	RUBBER SEAL
7	1	D4441-1-025	RUBBER SEAL
8	1	D4441-1-225	RUBBER SEAL
9	3	AN525-832R6	SCREW
10	12	MS20426AD3-2	RIVET
11	2	MS20426AD3-3	RIVET
12	5	MS20470AD4-3	RIVET
13	7	MS21075L08	NUT PLATE
14	A/R	3M 1300/1300L	ADHESIVE







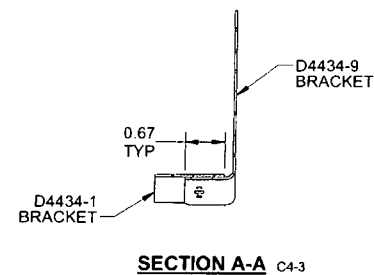
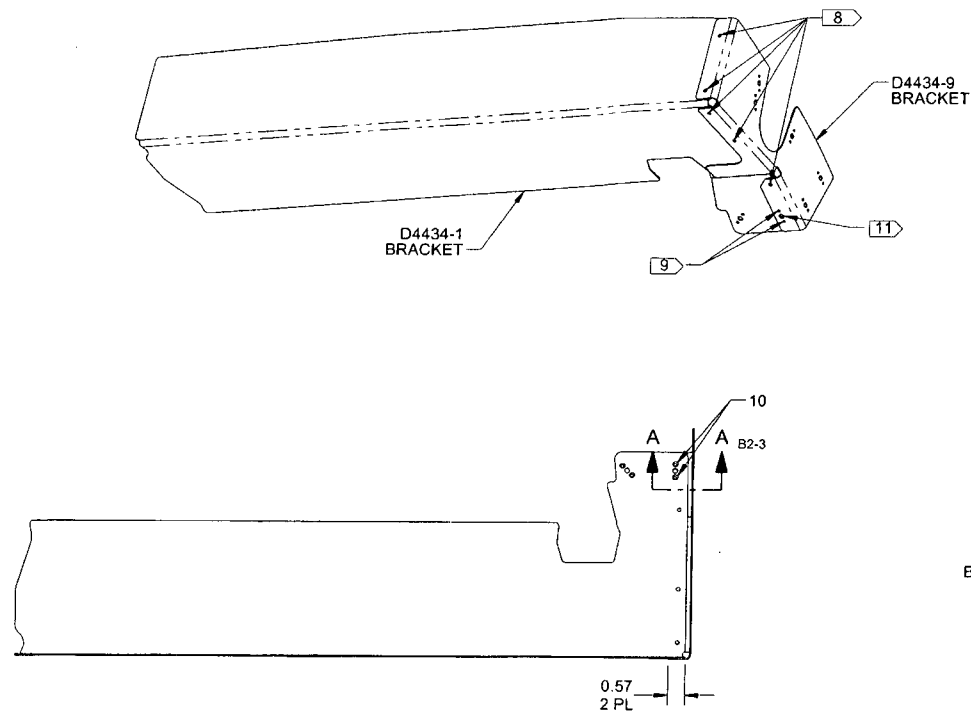
D4434-043 FWD INBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TORQUE SCREW TO 12-15 (in-lb)

RELEASED
2012-03-02

DESIGN	RF	DART AEROSPACE LTD.	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4434	REV. B
MFG. APPR.		SHEET 2 OF 15	
APPROVED		TITLE	SCALE
DE APPR.		COVER ASSEMBLY	
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		NTS	



SECTION A-A C4-3

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2012-03-02

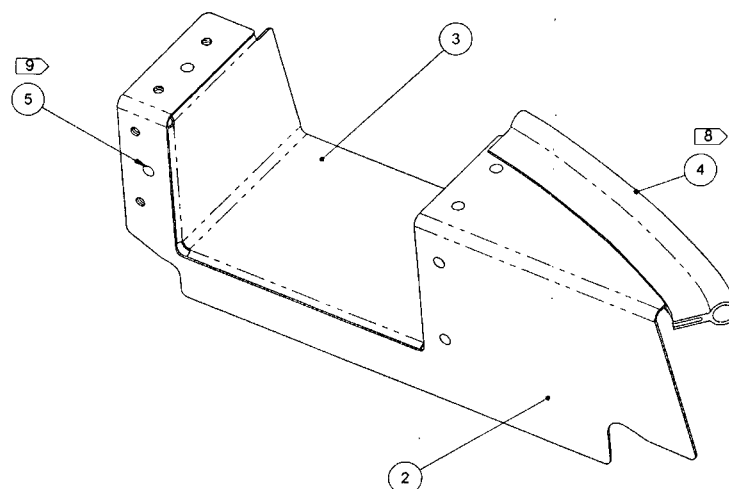
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs
- 8) TRANSFER $\varnothing 0.129$ HOLES THRU 5 PLACES FROM D4434-9 TO D4434-1
- 9) TRANSFER $\varnothing 0.098$ HOLES THRU 2 PLACES FROM D4434-9 TO D4434-1
- 10) CSK $\varnothing 0.179 \times 100^\circ$ ON THIS SIDE 2 PLACES
- 11) TRANSFER $\varnothing 0.177$ HOLE THRU FROM D4434-9 TO D4434-1

D4434-043 FWD INBOARD BRACKET ASSEMBLY
AUXILIARY VIEW

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	E	D4434	SHEET 3 OF 15
APPROVED	140	TITLE	SCALE
DE APPR.	#	COVER ASSEMBLY	NTS
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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
2	1	D4434-3	BRACKET
3	1	D4434-5	BRACKET
4	1	D4441-1-060	RUBBER SEAL
5	6	MS20426AD4-4	RIVET



D4434-045 FWD OUTBOARD BRACKET ASSEMBLY

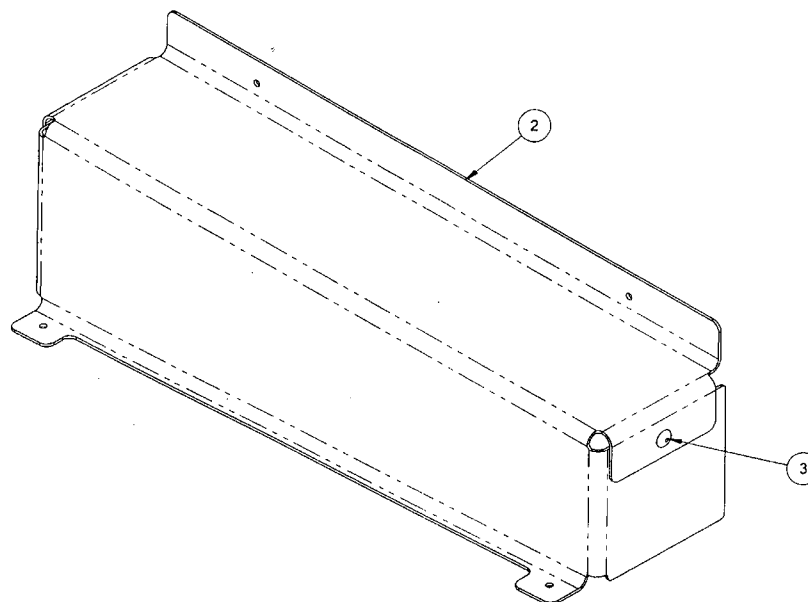
RELEASED
2012-03-02
MD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.365 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TRANSFER $\varnothing 0.129$ HOLE 6 PLACES AND CSK TO $\varnothing 0.225 \times 100^\circ$

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MD	DRAWING NO.	REV. B
MFG. APPR.	BE	D4434	SHEET 4 OF 15
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	COVER ASSEMBLY	NTS
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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D4434-047	COVER ASSEMBLY
2	1	D4434-7	BRACKET
3	2	MS20470AD4-3	RIVET



D4434-047 COVER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.263 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>MD</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BE</i>	D4434	SHEET 5 OF 15
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	COVER ASSEMBLY	NTS
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RELEASED
2012-03-02
MD

8 7 6 5 4 3 2 1

D

D

C

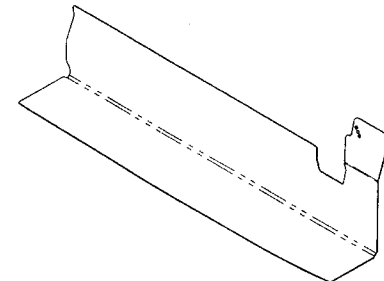
C

B

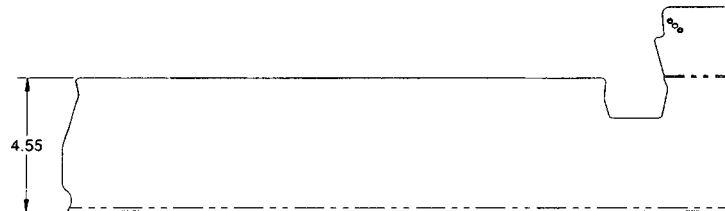
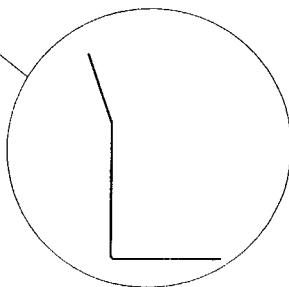
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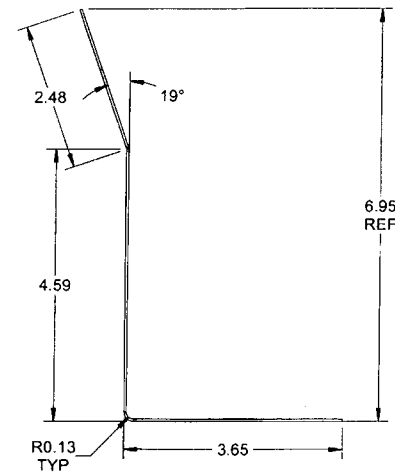
A



B
B2-6



4.55



6.95
REF

R0.13
TYP

3.65

DETAIL B C8-6
SCALE 2X

D4434-1 BRACKET

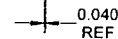
NOTES:

- 1) MATERIAL: MAKE FROM D4434-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

RELEASED
2012-03-02
JW

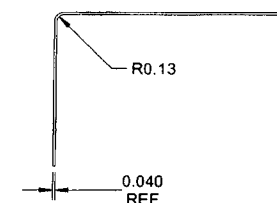
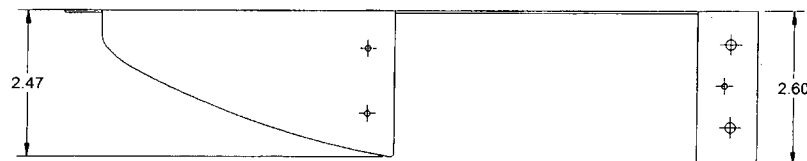
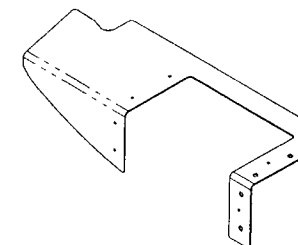
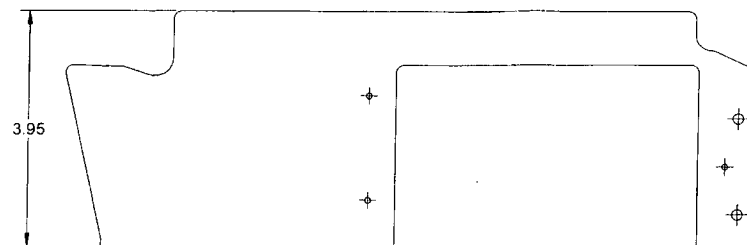
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MD</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>EE</i>	D4434	SHEET 6 OF 15
APPROVED	<i>MD</i>	TITLE	SCALE
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8 7 6 5 4 3 2 1



RELEASE
2012-03-02

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DRAWN	RF		SHEET 7 OF 15
CHECKED	<i>MF</i>		SCALE
MFG. APPR.	<i>MF</i>		NTS
APPROVED	<i>MF</i>		
DE APPR.	<i>MF</i>		
DATE	12.02.22		



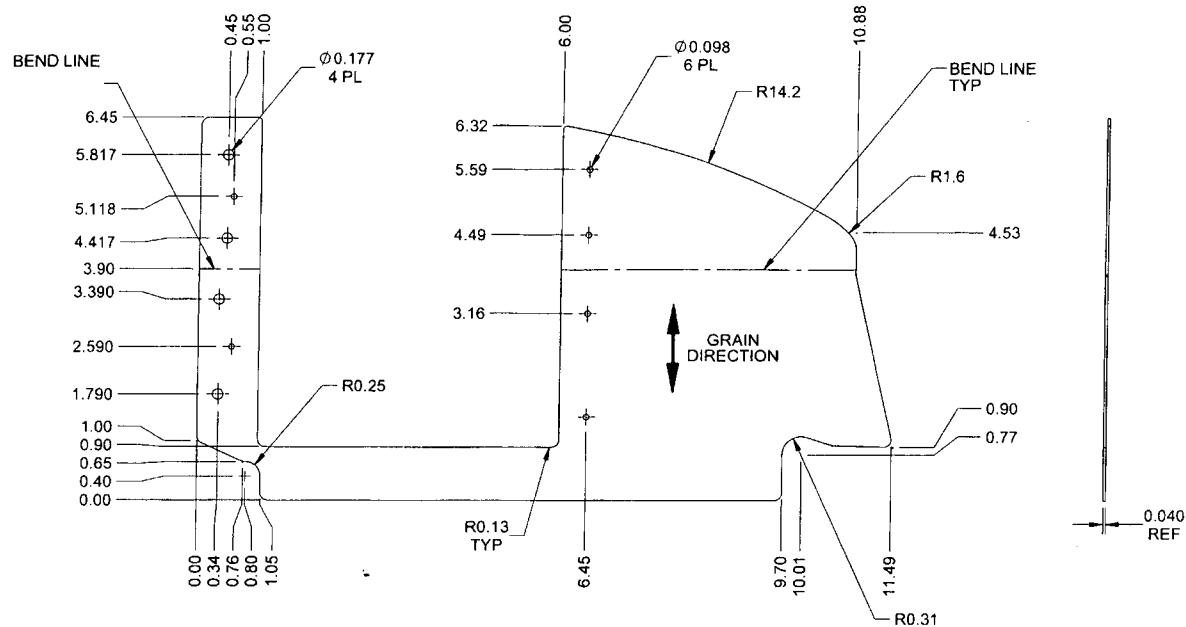
D4434-3 BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D4434-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>MD</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>EE</i>	D4434	SHEET 8 OF 15
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	COVER ASSEMBLY	NTS
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2012-03-02
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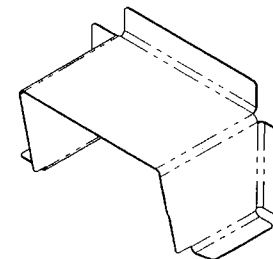
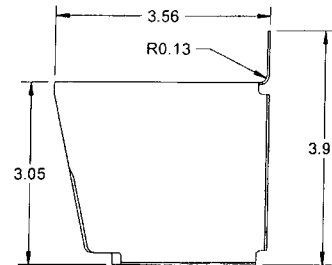
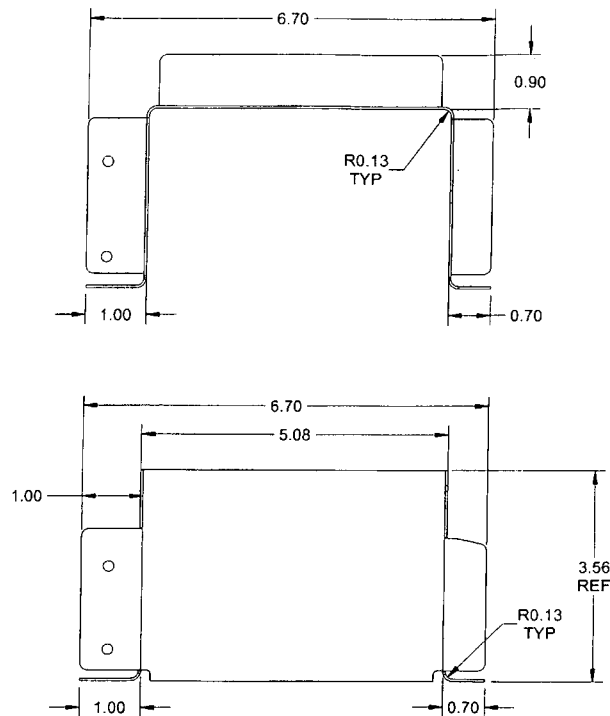
D4434-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D4434	REV. B SHEET 9 OF 15
MFG. APPR.	<i>RF</i>	TITLE COVER ASSEMBLY	SCALE NTS
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DE APPR.	<i>RF</i>		
DATE	12.02.22		

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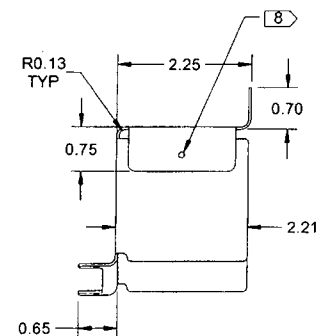
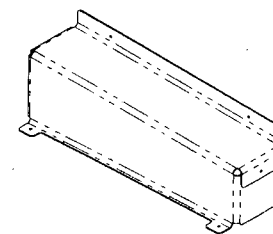
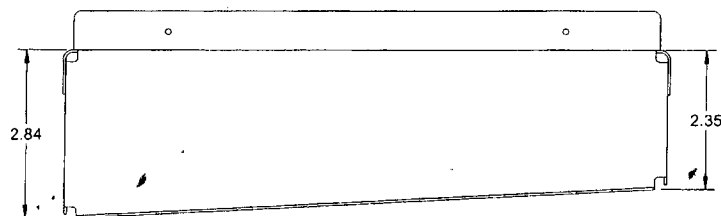
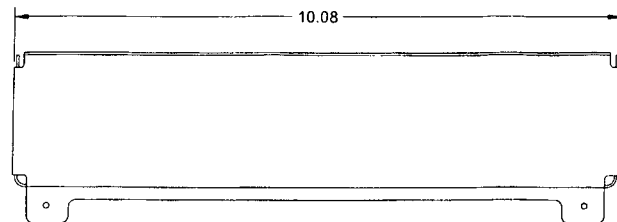
D4434-5 BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D4434-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO. D4434	REV. B
MFG. APPR.	<i>E</i>		SHEET 10 OF 15
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	COVER ASSEMBLY	NTS
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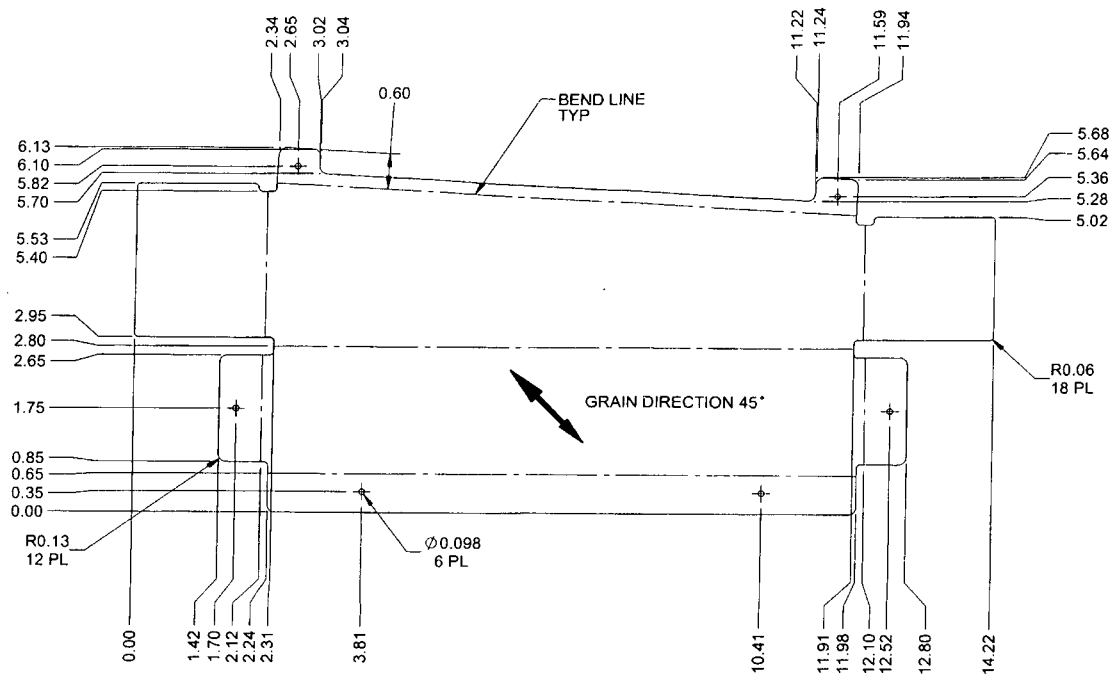
D4434-7 BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D4434-7F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs
- 8) TRANSFER $\varnothing 0.129$ HOLE THRU 2 PLACES

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. 8
MFG. APPR.	RF	D4434	SHEET 12 OF 15
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	COVER ASSEMBLY	NTS
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D4434-7F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4434	SHEET 13 OF 15
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	COVER ASSEMBLY	NTS
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